

Date: Tuesday, 04/11/2008 11:19:24 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 WEB
Job Number : 43191	
Estimate Number : 10466	
P.O. Number :	Part Number : D33891
This Issue : 04/11/2008 S.O. No. :	Drawing Number : D3389 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D
Previous Run : 43168	Material :
Written By :	Due Date : 24/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 08.11.04</u>	
Comment : Est Rev:A 05.08.31 New issue KJJ/JLM	
Est Rev:B 06-02-08 As per Rev C JLM	
Est Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -I' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Ext'n -I' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B40196

A.M 08.12.12 (4)

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

A.M 08.12.12 (4)

2-Drill pilot holes using DT8785 as per Dwg D3389

A.M 08.12.15 (4)

3-Open holes to finish size as per Dwg D3389

A.M 08.12.15 (4)

4-Deburr

A.M 08.12.15 (4)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

S 08/12/15 (4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M 08.12.15 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 43191

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP

8-12-15

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: JE

a.m

08.12.15

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-15

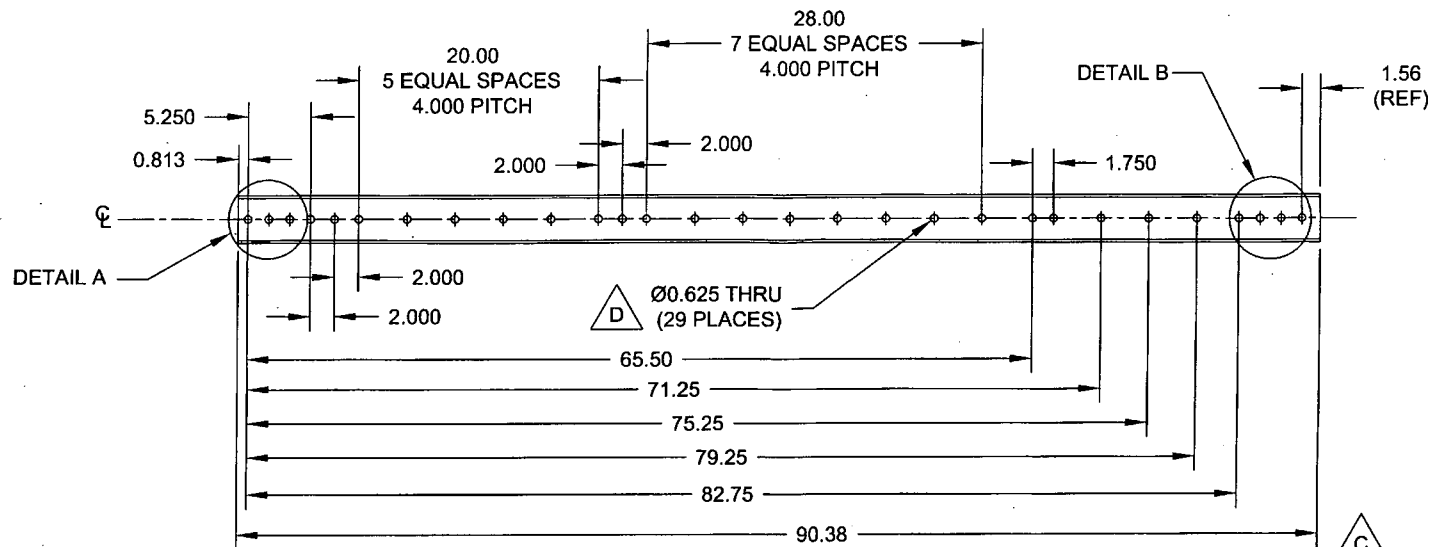
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

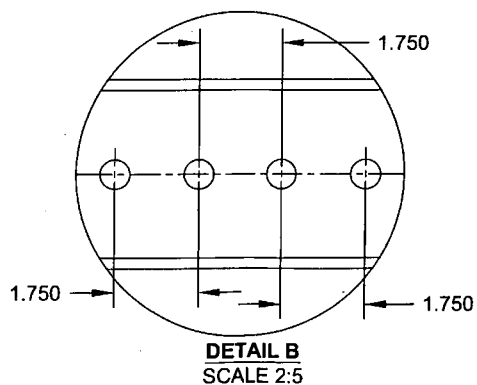
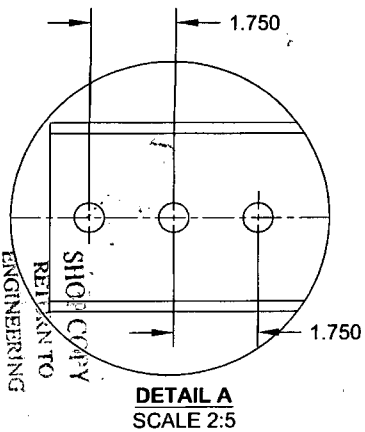
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3389-1 412 WEB



- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06

REV.	DESCRIPTION	BY	DATE
D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
DESIGN	DART AEROSPACE USA, INC		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO. REV. D		
MFG. APPR.	D3389 SHEET 1 OF 1		
APPROVED	TITLE SCALE		
DE APPR.	412 WEB 1:10		
DATE	07.10.09		

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